

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000245**Date Inspected:** 02-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson and Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector witnessed the completion of the first attempt of a PQR Test identified as ABF-PQR-025-1. This PQR test is being attempted using the flux-cored arc welding (FCAW) process and a mechanical device that travels on a magnetic track. Welder Dan Gordon deposited ten weld passes on this date. For specific welding parameters recorded during this PQR and digital photographs that support these observations, see Caltrans Welding Witness Report, TL-6032 generated on this date.

On this date, ABF Representative Mr. Tommy Gibson instructed Mr. Rick Clayborn to remove two previously welded PQR test plates identified as ABF-PQR-021-1C and ABF-PQR-022-2A and place them in a holding area instead of proceeding with further PQR testing at this time. Mr. Gibson informed the QA Inspector that he is placing the PQR test plates welded with Lincoln Ultracore Dual Shield E71T-1M on hold until results are received from the radiographic testing and destructive testing of the PQR identified as ABF-PQR-022-1. Mr. Gibson added that ABF would make a determination on whether or not to proceed with the other PQRs welded with this wire based on these results.

**Summary of Conversations:**

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Prior to welding, Quality Control Representative Mr. Michael Johnson informed the QA Inspector that the identified PQR would contain a separate zone for the root pass only.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Madere,Mary	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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